

Date: Wednesday, 4/5/2006 3:33:39 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TOW CAP
Job Number : 26590
Estimate Number : 10483
P.O. Number : N/A Part Number : D3401041
This Issue : 4/5/2006 S.O. No. : N/A Drawing Number : D3401 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : 25548 Material : N/A
Due Date : 4/24/2006 Qty: 10 Um: Each
Written By : See comment below
Checked & Approved By : 06.04.06
Comment : Est. A 06.09.01 New issue KJ/JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R3500	Inventory
Comment: Qty.: 0.3675 f(s)/Unit Total : 3.6750 f(s) Inventory <u>← see attached e-mail</u> Material: 6061-T6 Round Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6R3.500) Batch: <u>M16548</u> JF/MS 06/04/15 (10)		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut Blanks JF/MS 06/04/15 10		
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
Comment: MORI SEIKI CNC LATHE LARGE Turn as per Folio FA532 & Dwg D3401 Folio Rev: <u>AA</u> Dwg Rev: <u>B</u> Deburr JF/MS 06/04/15 10		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE JF/MS 06/04/15 10		
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: Haas #1 Machine as per Folio FA532 and Dwg D3401 Dwg Rev: <u>B</u> Folio Rev: <u>B</u> Identify as D3401-1 Deburr & Buff rad as per Dwg D3401 Ep 06/05/01 x10		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/5/2006 3:33:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW CAP

Job Number: 26590

Part Number: D3401041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J-G

06/05/02

10

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill and c'sink using DT8782 as per Dwg D3401

FF

06.05.23

10

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

06/05/23

10

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M

06/05/23

10

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m

06/05/24

10

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL

06/05/24

10

12.0 NAS1330C3KB116 Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Insert

Pick:

Qty Part number Description Batch

4 NAS1330C3KB116 Insert

Assemble as per Dwg D3401

Identify as D3401-041

19349

011005732

a.m

06-05-24

(10)

PTC

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL


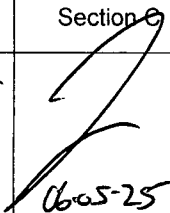
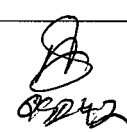
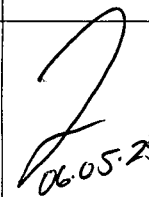
06/05/24

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-25	12	NAS 1330C3KB-166(x3) were installed in 1x D3401-041 fuel cap. Employee grabbed the wrong box (box is clearly I.D.) should use - 116, as per Dwg.		Ensure employee knows to properly read the req'd mat'l, or hardware specified, and double check. Remove and replace parts with the -116 as instructed. (new employee)	a.m. 06-05-25	 06-05-25		 06-05-25

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-14

DL 06/05/25

(10)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/05/25 (15)

Job Completion



u 06/05/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

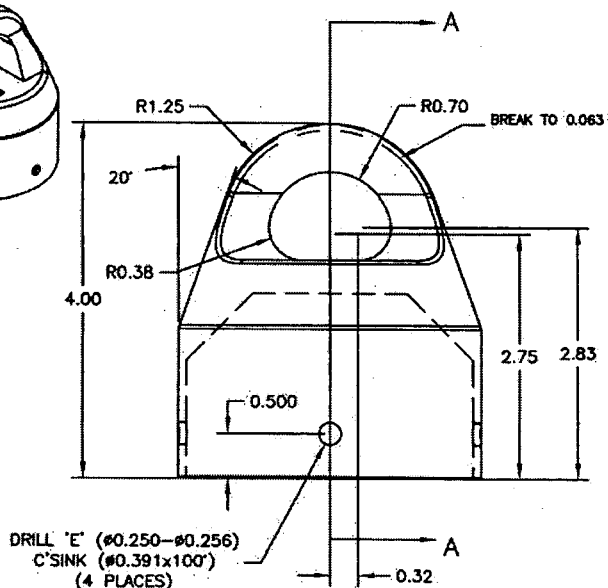
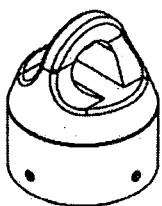
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

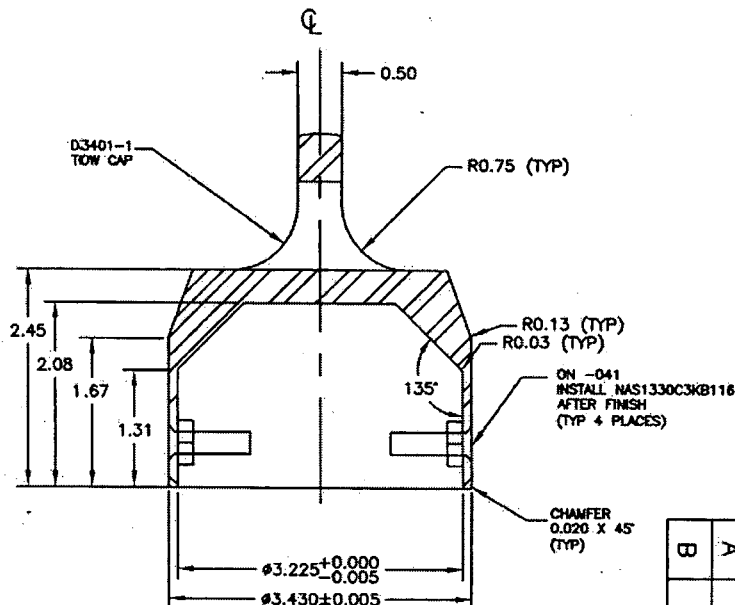
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



D3401-1 TOW CAP



SECTION A-A

D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 $\phi 3.500$ ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY.	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

WORK ORDER NO. 26590
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

RELEASED
05-08-07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
PH	PH	PORT HADLOCK, WA	REV. B
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
DATE		TITLE	SCALE
05.06.09		TOW CAP	1:2
A	05.02.24	NEW ISSUE	
B	05.06.09	CHAMFER INSIDE, REMOVE RADIUS	

Linda Lacelle

From: David Shepherd [davids@dartaero.com]
Sent: Friday, April 07, 2006 3:51 PM
To: Linda Lacelle
Cc: Bill Beckett; Peter Hum
Subject: Re: tow caps D3401-041

The 7075-T651 is an acceptable material substitution on the D3401-041 tow caps.

David

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>
To: "**David Shepherd (E-mail)" <davids@dartaero.com>
Cc: "Bill Beckett (E-mail)" <billb@dartaero.com>; "Peter Hum (E-mail)" <peterh@dartaero.com>
Sent: Friday, April 07, 2006 1:22 PM
Subject: tow caps D3401-041

>
> We show stock on the 6061 round bar, but it is not...we have 7075-T651 in
> stock, and since we have so many tribeams sold, I'd like to know if we can
> use this, for this time only, while we wait for the other mat'l to come
> in.
> Please let me know asap, as I'd like to have these run on the wknd.
> Thx
> LL
>

18